

QUALITY ASSURANCE PROVISIONS**C-321: SPECIFICATION:**

NSN: 5306-01-125-7031, P/N: (78286) 65130-07332-042
NOMEN: BOLT, ROTARY RUDDER CH-53 AIRCRAFT

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65130-07332-042 REV. "G", and all details and specifications referenced therein.

I. Quality/Inspection Requirements

- A. MIL-I-45208 applies: Refer to contract section E.
- B. First Article Testing applies: Refer to contract section I
- C. Production Lot Testing applies: Refer to contract section C
- D. Mandatory Inspection applies: Refer to contract section C.

II. Supplemental Requirements

- A. Additionally, para. 3.1-3.5, 5.1-5.2, 6.1-6.2 of MIL-Q-9858 apply.
- B. The contractor shall include on the detailed process/operation sheets developed, all in house manufacturing processes and the identity of all manufacturing sources performing processes/ operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of First Article or Production Lot Testing without approval from the basic design engineering activity via the PCO
- C. The Inspection Method Sheets which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging.
- D. Markings should be I/A/W MIL-STD-130 REV. "G" para. 5.3.3(a), (b), (c) and (g). Method and location shall be I/A/W drawing.

III. Mandatory Inspection Requirements:

During production, mandatory inspection is required to be accomplished by the contractor as follows:

- A. Level of Inspection (LOI).
 - 1) Critical Characteristics: 100% inspection shall apply.
 - 2) Major and Minor Characteristics - LOI shall be I/A/W a sampling plan acceptable to the QAR.

B. Critical Characteristics: P/N: (78286) 65130-07332-042

- 1) Sheet 1, NOTE 17
- 2) Sheet 1, NOTE 18
- 3) Sheet 1, Zone 8F

◎	C	.002 dia
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- 4) Sheet 2, Zone 3B NOTE 8
- 5) Sheet 2, Zone 5C 2.2489/2.2494 dia
- 6) Sheet 2, Zone 5C

◎	C	.002 dia
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C. Major and Minor Characteristics

- 1) Shall be defined by the contractor subject to QAR concurrence, unless defined on applicable drawings and associated specifications.

IV. Unless expressly provided for elsewhere in this Clause, equipment such as fixtures, jigs, dies, patterns, templates, mylars, special tooling, test equipment, or any other manufacturing aid required for the manufacture and/or testing of the subject item(s) will not be provided by the Government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing or referenced specification.

I-961 FIRST ARTICLE TESTS REQUIRED (GOVERNMENT TESTING)

I. First Article Inspection/Test Criteria:

The tests to be performed under the First Article approval clause of the contract are:

- A. Compliance with drawing (78286) 65130-07332-042 REV."G", and specifications referenced therein.
- B. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Article(s) to be delivered hereunder shall also be subjected to those tests which will demonstrate that the article(s) comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article Sample(s) during testing.

II. Samples to be submitted for testing: Quantity 2.

- A. Estimated Cost: T.B.D.
- B. Waiver of First Article Testing Requirements may be granted for (78286) Sikorsky Aircraft.

III. Testing shall be performed at the Government designated facility listed below.

NADEP Cherry Point
Attn: Betty Lupton, Code 544
MCAS Cherry Point, NC 28533

IV. Special Instructions

A. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to ready for issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant QAR. Sample(s) may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

B. Sample(s) will be returned to the contractor, if not destroyed in testing.

C. Sample(s) is to be unpainted. Corrosive areas are to be coated with a light preservative.

NOTIFICATION OF SHIPMENT OF MATERIAL FOR GOVERNMENT TESTING

Fourteen (14) days prior to shipment of First Article Sample(s), the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the PCO, Attn: 02. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR. Upon shipment of First Article Sample(s), two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to ASO Code 02, with duplicate copies to ASO Code 052 and to the designated test facility. The envelopes shall be clearly marked. "DO NOT OPEN IN MAILROOM".

Within 90days after receipt of sample(s) the test site shall complete testing/evaluation and submit two (2) copies of their test report with conclusions and recommendations to ASO Code 02.

I-964

FIRST ARTICLE APPROVAL (GOVERNMENT TESTING)

A. The contractor shall test 2 unit(s) of lot/item 0001 within 150 calendar days from the date of this contract to the Government at:

NADEP Cherry Point
F.A.T. Control Center
Attn: Betty Lupton, Code 544
MCAS Cherry Point, NC 28533

Marking of test sample(s) shipping container:
"FOR FIRST ARTICLE TESTING. NOT RFI MATERIAL. DO NOT TAKE UP IN STOCK. CONTRACT NUMBER: _____."

For First Article Test, the shipping documentation shall contain this contract number and the lot/item identification. The characteristics that the First Article must meet and the testing requirements are specified elsewhere in this contract.

B. Within 120 calendar days after the Government receives the First Article, the contracting officer shall notify the contractor, in writing, of the conditional approval, approval or disapproval of the First Article. The notice of conditional approval or approval shall not relieve the contractor from complying with all requirements of the specifications and all other terms and conditions of this contract. A notice of conditional approval shall state any further action required of the contractor. A notice of disapproval shall cite reasons for the disapproval.

C. If the First Article is disapproved, the contractor, upon Government request, shall submit an additional First Article for testing. After each request, the contractor shall make any necessary changes, modification, or repairs to the First Article or select another First Article for testing. All costs related to these tests are to be borne by the contractor, including any and all costs for additional tests following a disapproval. The contractor shall furnish any additional First Article to the Government under the terms and conditions and within the time specified by the Government.

The Government shall act on this First Article within the time limit specified in paragraph B above. The Government reserves the right to require an equitable adjustment of the contract price for any extension of the delivery schedule or for any additional costs to the Government related to these tests.

D. If the contractor fails to deliver any First Article on time, or the contracting officer disapproves any First Article, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract.

E. Unless otherwise provided in the contract, the contractor -

1) May deliver the approved First Article as a part of the contract quantity, provided it meets all contract requirements for acceptance and was not consumed or destroyed in testing and;

2) Shall remove and dispose of any First Article from the Government test facility at the contractor's expense.

F. If the Government does not act within the time specified in paragraph B or C above, the contracting officer shall, upon timely written request from the contractor, equitably adjust under the changes clause of this contract the delivery or performance dates and/or the contract price, and any other contractual term affected by the delay.

G. The contractor is responsible for providing operating and maintenance instructions, spare parts support, and repair of the First Article during any First Article Test.

H. Before First Article approval, the acquisition of materials or components for, or the commencement of production of, the balance of the contract quantity is at the sole risk of the contractor. Before First Article approval, the costs thereof shall not be allocable to this contract for 1) progress payments, or 2) termination settlements if the contract is terminated for the convenience of the Government.

I. The contractor shall produce both the First Article and the production quantity at the same facility and shall submit a certification to this effect with each First Article.

J. The contractor shall provide specific written notification to the procuring contracting officer informing him of the shipment of any article(s) furnished in accordance with this clause. Such notification must be addressed to the attention of ASO code 02 with copies to ASO code 052 and to the testing activity. Failure to provide such notification shall excuse the Government from any delay in performing First Article Testing and informing the contractor of the results thereof.

PRODUCTION LOT TESTING REQUIREMENTS

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

I. Production Lot Test Sampling Requirements

A. The cognizant CAO/QAR shall inspect the first production item. In addition the first production item from each successive lot shall be inspected by CAO/QAR.

B. Production Lot Testing to be completed during production after First Article approval.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

A. Compliance with drawing REV. "G", and specifications referenced therein.

B. Form

C. Dimensional Check 100%

D. Review of documentation as provided under CDRL (DD1423) requirements.

In addition to the above tests, the Production Lot Samples(s) to be delivered hereunder shall also be subjected to those tests which will demonstrate that the sample(s) comply with contract requirements.

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III. Testing Location, Cost and Estimated Leadtime

A. All testing to be accomplished at contractors facility.

B. Estimated Leadtime for Inspection/Test is 60 days.

Within fifteen days of completion of Production Lot Testing, the CAO/QAR shall prepare and submit two copies of their test report with conclusions and recommendations to the Contracting Officer.

IV. NOTIFICATION OF TESTING:

The contractor shall notify the PCO, ACO and QAR prior to conducting Production Lot Tests so that the Government may witness such testing.

A. The QAR shall be present to witness all Production Lot Tests.

V. Shipment and Distribution of Samples

A. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to Ready for Issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant CAO/QAR. Sample(s) may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

B. Sample(s) will be returned to the contractor.

A. The Production Lot Samples shall be the first production item selected at random by the cognizant government inspector.

B. Such samples shall be tested in sufficient time prior to the delivery date of the production articles to allow a 50 day period for testing and written notification by the contracting officer of the approval or disapproval of the samples. Within 30 days of the receipt of the samples, the CAO shall notify the contracting officer, Aviation Supply Office code 02, of the results of the testing, together with a recommendation for approval or disapproval.

C. In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular production lot within 50 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.

D. If the contractor fails to deliver any Production Lot Samples for testing within the time or times specified, or if the contracting officer disapproves any Production Lot Samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract, and this contract shall be subject to termination for default.

E. In order for a Production Lot to be acceptable, all samples representative of the lot must pass all the contract requirements. In the event a sample fails to pass such requirements, the lot will be rejected. In such event, the government may, at its option and at no additional cost to the government, (I) terminate all or any portion of this contract for default, (II) require the manufacture of a new Production Lot, or a rework of the rejected Production Lot if the means and procedures proposed by the contractor for rework are acceptable to the government, or (III) require the submission of additional samples for test. The foregoing procedures shall apply to new or reworked production lots in the same way as they did to the original Production Lot.

F. For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of a failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the costs of reinspection, examination and retesting and the contractor and his sureties (if any) shall be liable for the amount of such costs.

G. Nothing contained in the foregoing provisions of this clause, and no action of the government in accordance herewith, shall in any way prejudice the right of the government under the clause of this contract entitled Default.

CONTRACT DATA REQUIREMENTS LIST

Form Approved
OMB NO. 0704-0188

Public reporting burden for this collection of information is estimated to average 440 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send completed form to the Government issuing Contracting Officer for the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY TDP _____ TM _____ OTHER <u>engineering</u>	
D. SYSTEM/ITEM IRM 5306-01-125-7031		E. CONTRACT/PR NO.		F. CONTRACTOR	
1. DATA ITEM NO. 0001	2. TITLE OF DATA ITEM CERTIFICATION DATA REPORTS			3. SUBTITLE COMPLETE PROCESS/OPERATION SHEETS	
4. AUTHORITY (Data Acquisition Document No.) DI-MISC-80678/T		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP/CHERRY POINT	
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQUIRED	12. DATE OF FIRST SUBMISSION SEE BLOCK 16 *	DISTRIBUTION	
8. APP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK 16 **	a. ADDRESSEE NADEP/CHRYPT	b. COPIES Draft FINAL Reg Repr
16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 APPLY * UPON SUBMISSION OF FIRST ARTICLE TEST AND/OR PRODUCTION LOT SAMPLES ** IF THE PROCESS/OPERATION CHANGE AFTER APPROVAL OF F.A.T. AND/OR PRODUCTION LOT APPROVAL				CODE 544	* 1/0
				CAO	** 1/0
				ASO/0534	* 1/0
				15. TOTAL	3/0
1. DATA ITEM NO. 0002	2. TITLE OF DATA ITEM CERTIFICATION DATA/REPORTS			3. SUBTITLE COMPLETED INSPECTION METHOD SHEETS	
4. AUTHORITY (Data Acquisition Document No.) DI-MISC-8-0678/T		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NADEP/CHERRY POINT	
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQUIRED	12. DATE OF FIRST SUBMISSION SEE BLOCK 16 *	DISTRIBUTION	
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK 16 **	a. ADDRESSEE NADEP/CHYPT	b. COPIES Draft FINAL Reg Repr
16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 APPLY * UPON SUBMISSION OF FIRST ARTICLE TEST AND/OR PRODUCTION LOT SAMPLES * TIME OF CONTRACT COMPLETION				CODE 544	* 1/0
				CAO/QAR	** 1/0
				ASO/0534	1/0
				15. TOTAL	4/0
1. DATA ITEM NO. 0003	2. TITLE OF DATA ITEM REQUEST FOR DEVIATION			3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.) DI-CMAN-80640		5. CONTRACT REFERENCE		6. REQUIRING OFFICE ASO	
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ.	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
8. APP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES Draft FINAL Reg Repr
16. REMARKS ORIGINAL				ASO/02	1/0
				15. TOTAL	1/0
1. DATA ITEM NO. 0004	2. TITLE OF DATA ITEM REQUEST FOR WAIVER			3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.) DI-CMAN-80641		5. CONTRACT REFERENCE		6. REQUIRING OFFICE ASO	
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ.	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
8. APP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES Draft FINAL Reg Repr
16. REMARKS ORIGINAL AND TWO COPIES				ASO/01	1/0
				15. TOTAL	1/0
I. PREPARED BY VITALEC 0534.14		H. DATE		J. DATE	
I. APPROVED BY					

17. PRICE GROUP

18. ESTIMATED
TOTAL PRICE

17. PRICE GROUP

18. ESTIMATED
TOTAL PRICE

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TOTAL PRICE

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CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY TDP _____ TM _____ OTHER <u>ENGINEERING</u>	
SYSTEM/ITEM 5306-01-125-7031		E. CONTRACT/PR NO.		F. CONTRACTOR	
1. DATA ITEM NO. 0005	2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT			3. SUBTITLE CRITICAL PROCESS SORUCES	
4. AUTHORITY (Data Acquisition Document No.)		5. CONTRACT REFERENCE		6. REQUIRING OFFICE	
7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE NADEP/CHYPT	b. COPIES Draft FINAL Reg Reprs
16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 APPLY UPON SUBMISSION OF FIRST ARTICLE AND/OR PRODUCTION LOT SAMPLE				CODE 544	1/0
				CAO	1/0
				ASO/0534	1/0
				15. TOTAL	3/0
1. DATA ITEM NO. 0006	2. TITLE OF DATA ITEM ENGINEERIN GCHANGE PROPOSAL			3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.) DI-CMAN-80604		5. CONTRACT REFERENCE		6. REQUIRING OFFICE ASO	
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQUIRED	12. DATE OF FIRST SUBMISSION SEE BLOCK 16	DISTRIBUTION	
8. APP CODE A		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES Draft FINAL Reg Reprs
16. REMARKS ORIGINAL				ASO/02	1/0
				15. TOTAL	1/0
1. DATA ITEM NO.	2. TITLE OF DATA ITEM			3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.)		5. CONTRACT REFERENCE		6. REQUIRING OFFICE	
7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES Draft FINAL Reg Reprs
16. REMARKS					
				15. TOTAL	
1. DATA ITEM NO.	2. TITLE OF DATA ITEM			3. SUBTITLE	
4. AUTHORITY (Data Acquisition Document No.)		5. CONTRACT REFERENCE		6. REQUIRING OFFICE	
7. DD 250 REQ	9. DIST STATEMENT REQUIRED	10. FREQUENCY	12. DATE OF FIRST SUBMISSION	DISTRIBUTION	
8. APP CODE		11. AS OF DATE	13. DATE OF SUBSEQUENT SUBMISSION	a. ADDRESSEE	b. COPIES Draft FINAL Reg Reprs
16. REMARKS					
				15. TOTAL	
PREPARED BY VITALEC 0534.14		H. DATE		I. APPROVED BY	
				J. DATE	

17. PRICE GROUP

18. ESTIMATED
TOTAL PRICE

17. PRICE GROUP

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17. PRICE GROUP

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TOTAL PRICE

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OMB No. 0704-0188

A. CONTRACT LINE ITEM NO.	B. EXHIBIT	C. CATEGORY: TOP _____ TM _____ OTHER _____
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1. DATA ITEM NO. 7	2. TITLE OF DATA ITEM CERTIFICATION DATA/REPORTS	3. SUBTITLE
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17. PRICE GROUP	
18. ESTIMATED TOTAL PRICE	

PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 APPLY

BLOCK #12 UPON SUBMITTAL OF FIRST ARTICLE TESTING SAMPLE(S)

BLOCK #3 SEPARATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUBTITLES CERTIFICATION REPORTS FOR PRIME PROCESS AND MATERIAL SPECIFICATIONS SHALL INCLUDE CERTIFICATION THAT ALL VENDORS PERFORMING THESE PROCESSES ARE PRIME (OEM) APPROVED SOURCES.

BLOCK # 5 CONTRACT REFERENCE: P/N: (78286) 65130-07332-042
MADE FROM 4340 COND. C

1. BRUSH CADMIUM PLATE PER MIL-STD-865
2. CADMIUM PLATING PER SS 8489 NOTE 7
3. MAGNETIC PARTICLE INSPECTION PER SS 8805
4. HEAT TREATMENT PER MIL-H-6875
5. SHOT PEEN PER MIL-S-13165
6. FINISH GRINDING PER SS 8705

[illegible]

G. PREPARED BY	H. DATE	I. APPROVED BY	J. DATE
G. WITALEC 0534.14			